

Work Order ID 88666

July-30-12 10:21:50 AM

Item ID: D3916-5

Accept

Revision ID:

Item Name: Light Rib

Start Date: 30/07/2012 Start Qty: 4.00

4
4
3X

Required Date: 13/08/2012 Req'd Qty: 4.00

N900040100

Setup Start

NS1

Stop

NS2

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

Date: 12/07/12 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3916	A
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100 0.00

100

Large Fab

Memo
1- Cut tube 50"
2- Bend tube with manuel pipe bender as per DT9566
*** Make line at 9.00" and use jig for other line***
3- Trim access tube material to finish size as per dwg D3916

3X CC 13-05-6

110

QC6- Inspect dimensions to drawing 0.00

110

QC

Quality Control

3 B-05-06

DAS
09
889

120

Identify as per dwg & Stock Location: WIA 0.00

120

Packaging

Packaging

3X CC 13-05-6

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>					
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>					
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>					
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
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Landing Gear				General								
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	<hr/>											

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Page 2

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Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

MWS 13-05-08

Quality Control

MLB 05/08/12

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>																																																																																				
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Picklist Print

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Page 1

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88666

Parent Item: D3916-5

D3916-5

Parent Item Name: Light Rib

Start Date: 30/07/2012

Required Date: 13/08/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
as per dwg revA 10.03.15 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased	No			100	f	1,049.099	4.166	17.54105	**		

M304TS0 500W 049

Square Tubing

Location	Loc Qty	Loc Code
MAT018	644	B123365 → 13.155
122413	644	
MAT034	405.0995823	
118460	0.00001534	
121328	2.059994	
121565	20.775743	
121808	382.26383	

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
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8

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4

3

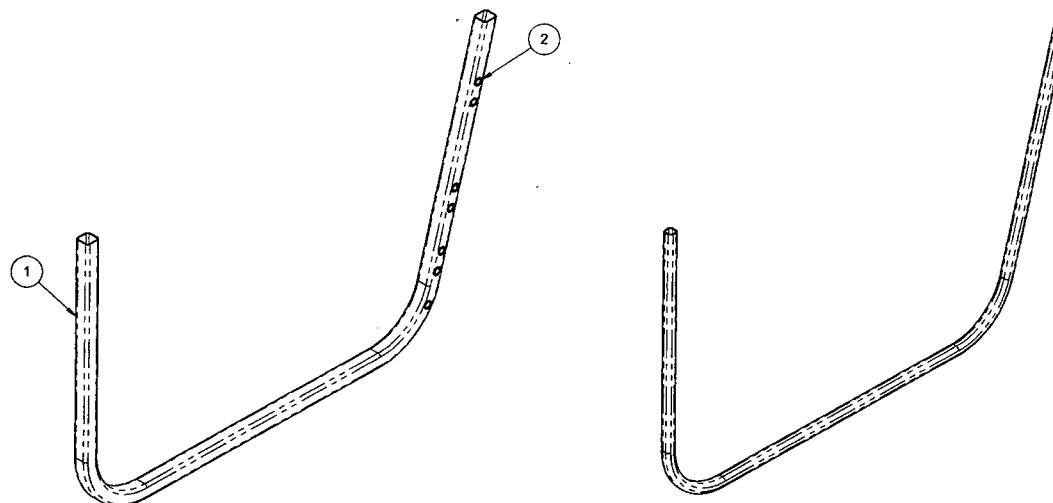
2

1

ITEM	QTY	P/N	DESCRIPTION
	-041		
X		D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

D

D

D3916-041 RIB ASSYD3916-5 LIGHT RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 88666 MUJ
12/07/130

OK 10.12.21
UNDER REVIEW
A 10.10
ADDITION OF HOLE & BUSHINGS
ON D3916-041-1 RIBS.
RELEASED
2010-03-12
MP

A	NEW ISSUE		JPJ	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS			
DRAWN	JPH			
CHECKED	<u>Q</u>			
MFG. APPR.	<u>E</u>			
APPROVED	<u>MP</u>			
DE APPR.	<u>MP</u>			
DATE	10.03.04		SCALE	NTS
	RIB ASSY, 350 BASKET		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWING NO. D3916		REV. A	
	SHEET 1 OF 4			
	COPRIGHT © 2010 BY DART AEROSPACE LTD			
	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS ISSUED ON THE EXPRESS CONDITION THAT IT IS			
	NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT			
	WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8

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2

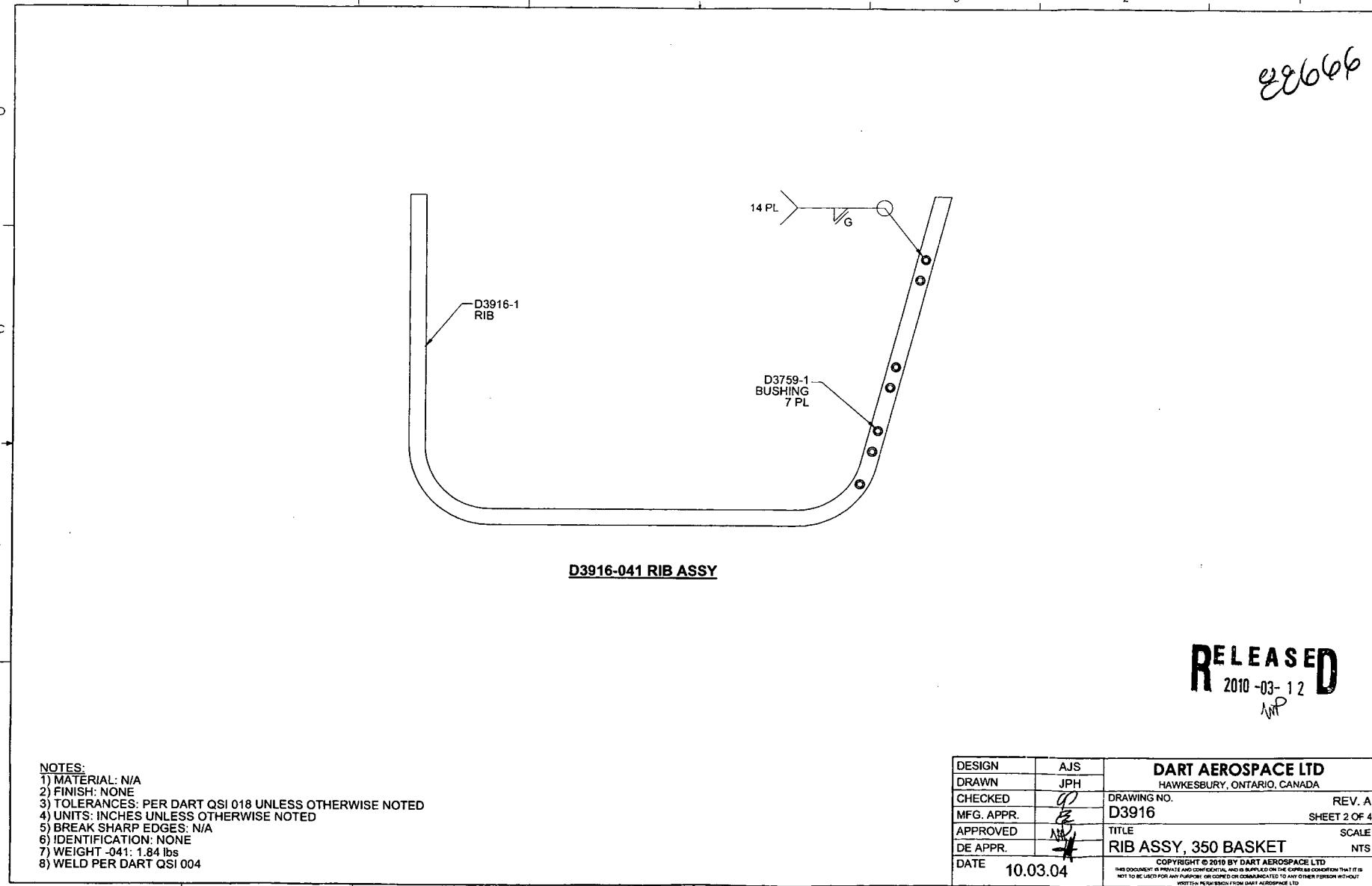
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A

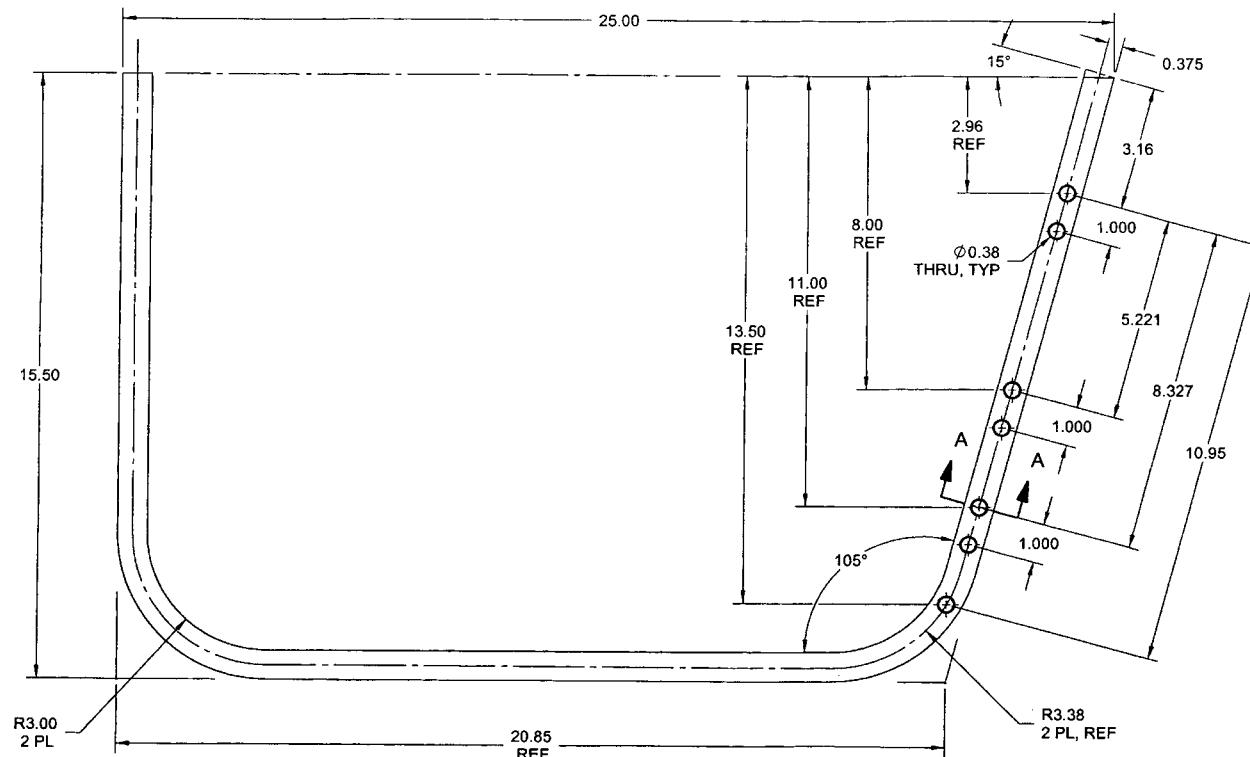
B

C

C



88664



9 D3916-1 RIB

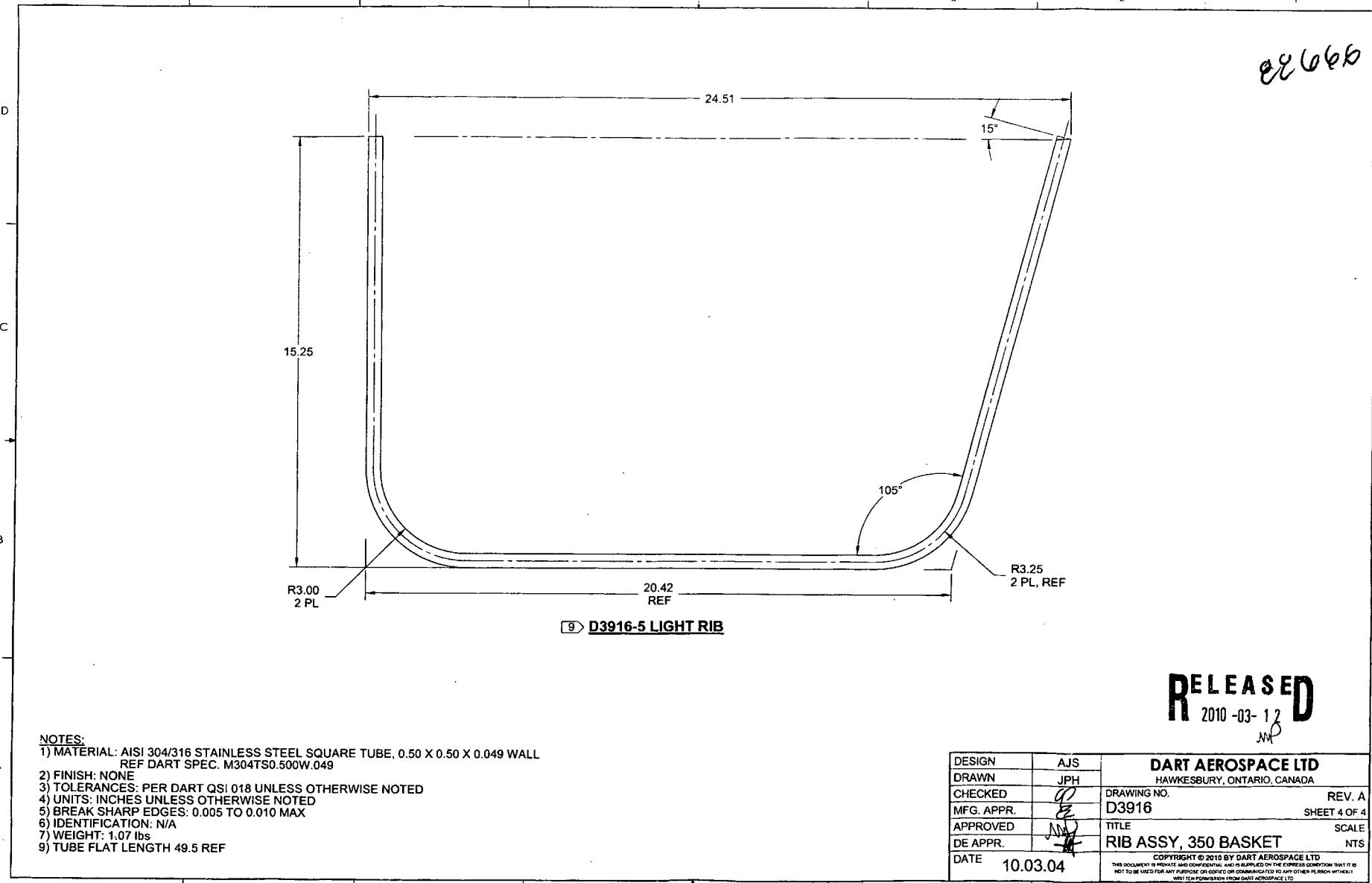
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>GD</i>	DRAWING NO.
MFG. APPR.	<i>GD</i>	REV. A
APPROVED	<i>GD</i>	D3916
DE APPR.	<i>GD</i>	SHEET 3 OF 4
DATE	10.03.04	TITLE
RIB ASSY, 350 BASKET		
NTS		
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RELEASED
2010-03-12
NP

8 7 6 5 4 3 2 1



RELEASED
 2010-03-12
 MM